

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020524**Date Inspected:** 06-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. LIU HUA JIE**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Santhosh Ramakrishna was present during the times noted above for observations relative to fabrication work of the Self Anchored Suspension (SAS) Superstructure being performed.

This QA inspector randomly observed the following work:

**1. INPROCESS:**

Orthotropic Box Girder (OBG) at Trial Assembly Area:

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Fillet welds joining the drip plate to edge plate weld joint located on 11BE+11CE at cross beam side. The weld is designated as OBE11D-085 & 090.

The welder is identified as 040270. ZPMC QC Mr. LIU HUA JIE was onsite monitoring the welding variables.

The inprocess SMAW appears to be progressing in compliance with WPS-B-P-2114-FCM-1.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP)

welds joining the edge plate to side plate hold back weld joint located on 11EE+12AE at cross beam side. The

weld is designated as CA093-005(11EE) & SEG3001A-002(12AE). The welder is identified as 050289. ZPMC

QC Mr. AN QING XING was onsite monitoring the welding variables. The inprocess SMAW appears to be

progressing in compliance with WPS-B-P-2214-TC-U4b-FCM-1. See the attached picture for detail of weld joint.

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### 2. NDT:

Ultrasonic Testing (UT) (A, B, C and D-Scan):

UT carried out as per the ABF submitted UT Notification No 12042010-2, Item No 2.

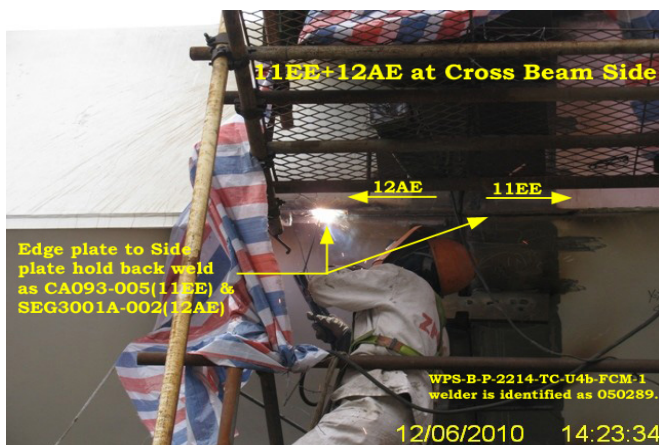
This QA Inspector performed Ultrasonic testing (UT) 10 % of the area that has been previously tested and accepted by ABF Quality control personnel. This QA inspector generated a UT (TL-6027) report on this date. The members are identified as butt joint between deck plate to deck plate transverse splice weld joint located on 11DW+11EW. According to rejection criteria of "D" Scan procedure that Caltrans QA did not find any Rejected indication at scanning area. The Weld Designation is as follows: OBW11A-008, 007.

Ultrasonic Testing (UT) (A, B, C and D-Scan):

UT carried out as per the ABF submitted UT Notification No 12042010-2, Item No 3.

This QA Inspector performed Ultrasonic testing (UT) 10 % of the area that has been previously tested and accepted by ABF Quality control personnel. This QA inspector generated a UT (TL-6027) report on this date. The members are identified as butt joint between side plate to side plate transverse splice weld joint located on 11DW+11EW at cross beam side. According to rejection criteria of "D" Scan procedure that Caltrans QA did not find any Rejected indication at scanning area. The Weld Designation is as follows: OBW11C-009, 010.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No relevant conversations were reported on this date.

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### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Pillai,Santosh

Quality Assurance Inspector

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**Reviewed By:** Miller,Mark

QA Reviewer